CLAIMS

Therefore, having thus described the invention, at least the following is claimed:

1. A method for forming a masonry unit, said method comprising the steps of:
joining a pallet to a bottom surface of a mold;
inserting a filler plug into the side of the mold between a partition plate and a pallet;
dispensing mix into the mold; and
compressing the mix with a shoe to form a masonry unit with a filler plug effect.

2. The method of claim 1, further including the step of removing the filler plug.

3. The method of claim 1, further including the step of stripping the architectural concrete masonry unit from the mold by lowering the pallet.

4. The method of claim 1, wherein the filler plug effect is a bottom bevel.

5. The method of claim 1, wherein the filler plug effect is a mortar buffer surface.

6. The method of claim 1, wherein the step of joining includes raising the pallet up with respect to the mold.

7. The method of claim 1, further including opposing side gussets.

8. The method of claim 7, wherein the opposing side gussets, the filler plug, and the shoe are configured with angled surfaces that form an angle of inclination between a front surface and opposing side surfaces, a top surface, and a bottom surface of the masonry unit.

9. The method of claim 8, wherein the angled surface of the filler plug includes an angle of approximately 30 degrees between a bottom surface of the filler plug and the angled surface.

10. The method of claim 8, wherein the angled surface of the filler plug includes an angle in a range of approximately 10-60 degrees between a bottom surface of the filler plug and the angled surface.

11. The method of claim 8, wherein the angled surface of the filler plug includes has a width of approximately 7/32 inch.

12. The method of claim 8, wherein the angled surface of the filler plug has a width in the range of approximately 1/16 inch – ½ inch.

13. The method of claim 8, wherein the angled surface of the shoe includes an angle of approximately 150 degrees between a bottom surface of the shoe and the angled surface.

14. The method of claim 8, wherein the angled surface of the shoe includes an angle in a range of approximately 120 – 170 degrees between a bottom surface of the shoe and the angled surface.

15. The method of claim 8, wherein the angled surface of the shoe has a width in the range of approximately 1/16 inch – ½ inch.

16. The method of claim 8, wherein the angled surface of the shoe has a width of approximately 7/32 inch.

17. The method of claim 8, wherein the angled surface of the opposing side gussets include an angle of approximately 150 degrees between a partition plate in contact with the opposing side gussets and the angled surface of the opposing side gussets.

18. The method of claim 8, wherein the angled surface of the opposing side gussets include an angle in a range of approximately 120 – 170 degrees between a partition plate in contact with the opposing side gussets and the angled surface of the opposing side gussets.

19. The method of claim 8, wherein the angled surface of the opposing side gussets has a width in the range of approximately 1/16 inch – ½ inch.

20. The method of claim 8, wherein the angled surface of the opposing side gussets has a width of approximately 7/32 inch.

21. The method of claim 8, wherein the angle of inclination is a substantially constant angle of inclination.

22. The method of claim 1, wherein the step of inserting a filler plug includes the step of inserting a plurality of filler plugs.

23. The method of claim 1, wherein the filler plug is further configured with a "T" portion that includes a beveled surface to form a bottom corner bevel in at least one of a segmented retaining wall block, a concrete masonry unit, and an architectural concrete masonry unit.